

# Work Order ID 119039

May-06-14 8:10:14 AM

\*119039\*

Page 1

Item ID: D3885-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Standard Web  
 Start Date: 4/30/14 Start Qty: 12.00 \*12\* Cust Item ID:  
 Required Date: 5/05/14 Req'd Qty: 12.00 \*12\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 140507 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	B								

100 0.00  
 \*100\*  
 Purchasing Memo 0.00  
 Purchasing  
 Issue P/O: 24244  
 Supplier: George A. Wright & Son Ltd.  
 Machine as per Dwg D3885  
 Conformity sheet required Wujay.

CL 14/05/16 21

110 0.00  
 \*110\*  
 Packaging Memo 0.00  
 Packaging

6/17/20 64

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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# Work Order ID 119039

May-06-14 8:10:14 AM

**\*119039\***

Page 2

Item ID: D3885-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Standard Web

Start Date: 4/30/14 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

DAS

27

9-89

**\*120\***

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

Hand Finish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

**\*140\***

QC

Memo

0.00

Quality Control

DAS  
18  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b>  <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b>  <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Work Order ID 119039

May-06-14 8:10:14 AM

\*119039\*

Page 3

Item ID: D3885-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Standard Web

Start Date: 4/30/14 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 5/05/14 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>4/6</u>	0.00				(21)			
*150*									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
*160*									
QC	Memo	0.00							
Quality Control									

DGL 14-6-25

MLJ 14-6-25

MF 14-6-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Page 1

May-06-14 8:10:14 AM

Work Order ID: 119039

\*119039\*

Parent Item: D3885-1

\*D3885-1\*

Parent Item Name: Standard Web

Start Date: 4/30/14

Required Date: 5/05/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130		Manufactured	No			110	Each	21.0000	1	12 21			
*D3882-1-130*													
Extrusion "I" Beam													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				HALL				21					
					93832			21					
D3885-1P		Purchased	No				Each	0.0000		12 21			
*D3885-1P*													
Standard Web													

CLY/05/14

10/17/20 (21)

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

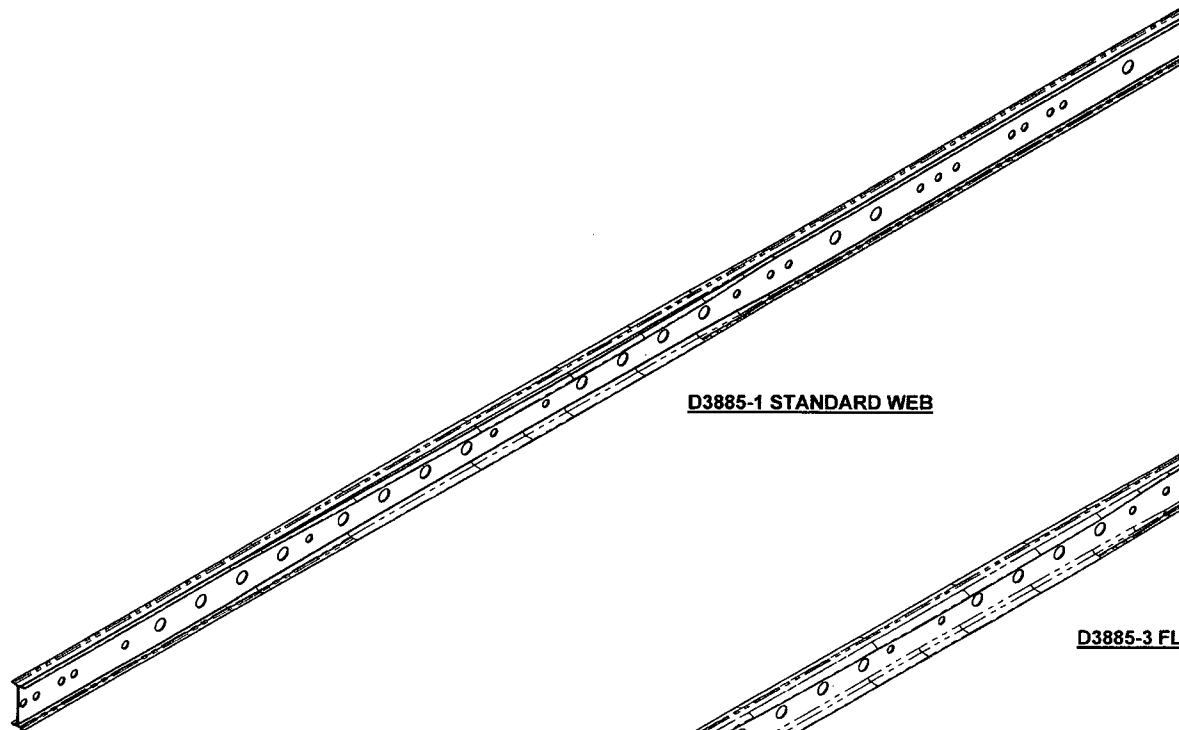
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
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### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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**D3885-1 STANDARD WEB**

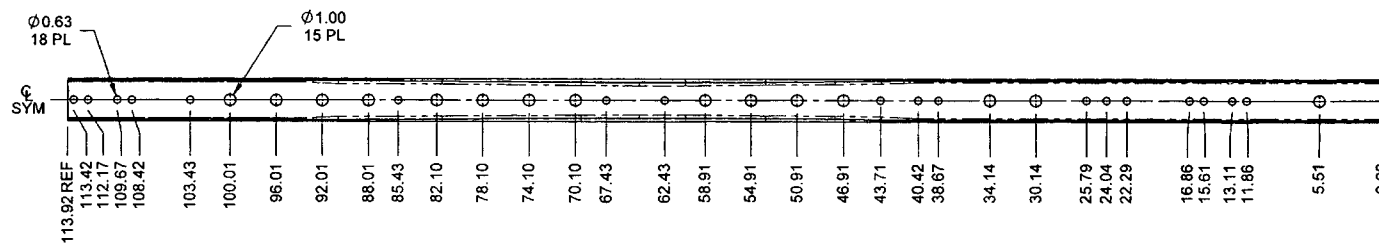
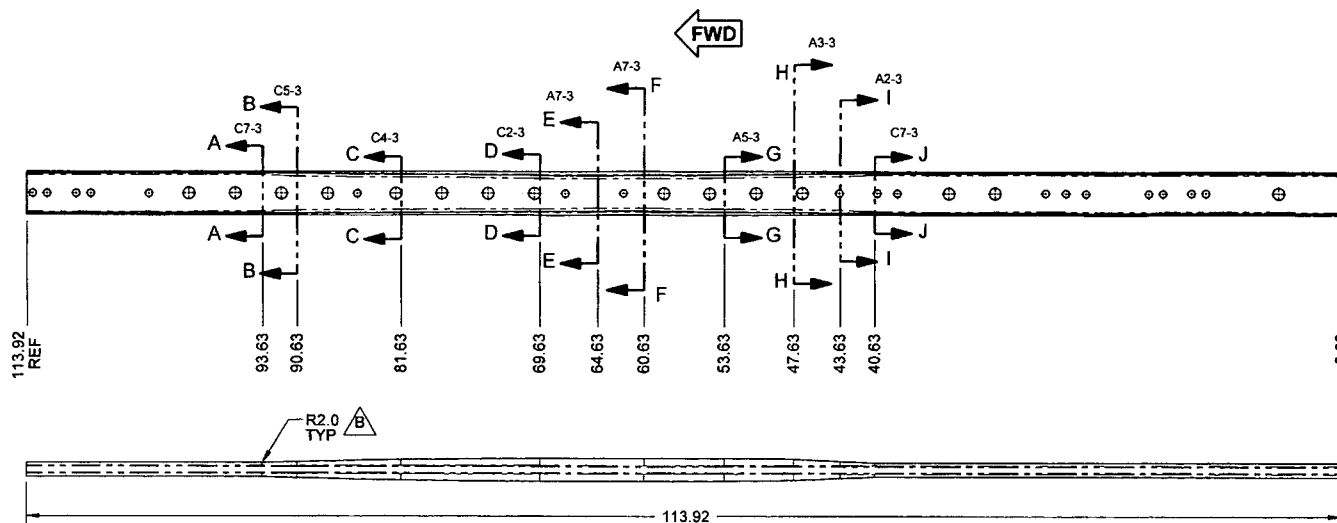
**D3885-3 FLOAT WEB**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 119039 MLJ

14-05-07

**RELEASED**  
*06/15/07*

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5), ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	





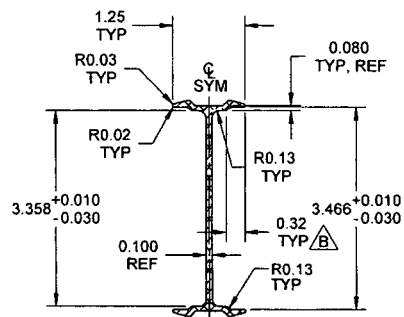
# **D3885-1 STANDARD WEB**

**RELEASED**  
09/27/15

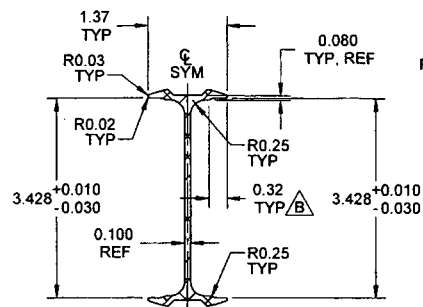
## **D3885-1 NOTES:**

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

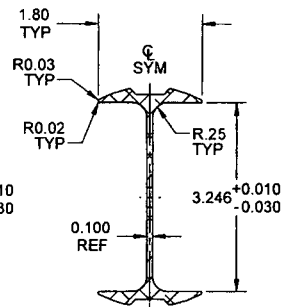
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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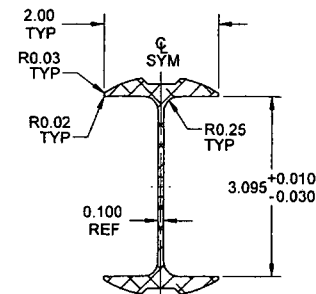
**SECTION A-A  
& SECTION J-J**  
SCALE 5X  
D6-2  
D4-2



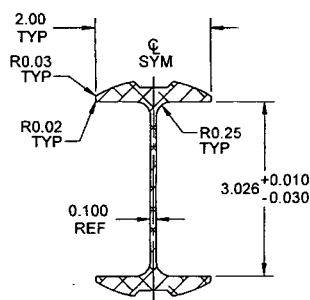
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SCALE 5X  
D6-2



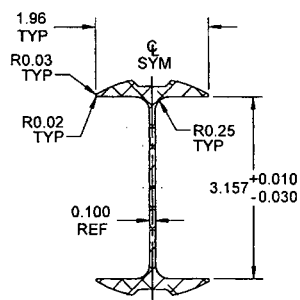
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D6-2



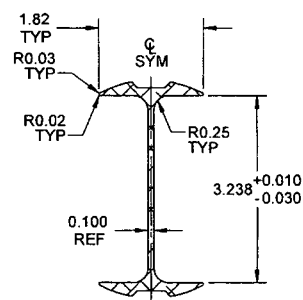
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D5-2



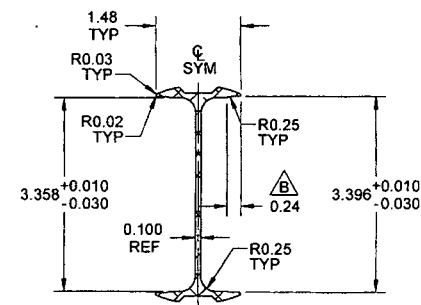
**SECTION E-E  
& SECTION F-F**  
SCALE 5X  
D5-2



**SECTION G-G**  
SCALE 5X  
D4-2



**SECTION H-H**  
SCALE 5X  
D4-2

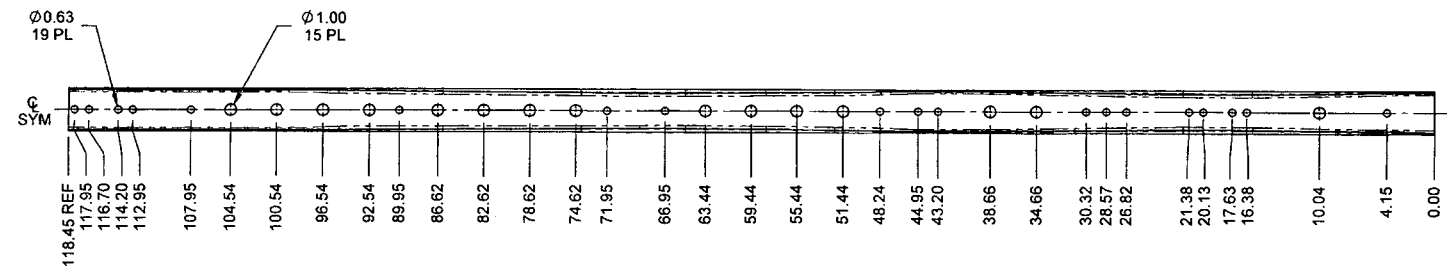
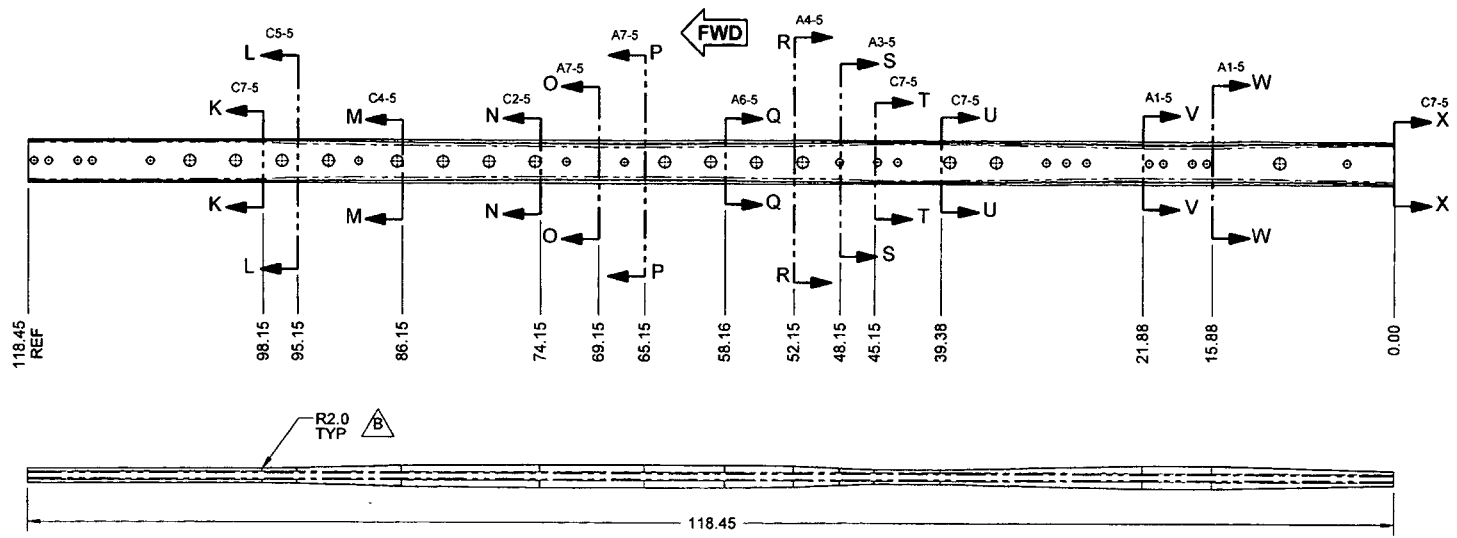


**SECTION I-I**  
SCALE 5X  
D4-2

**D3885-1 STANDARD WEB SECTION VIEWS**

**RELEASED**  
09/07/15





DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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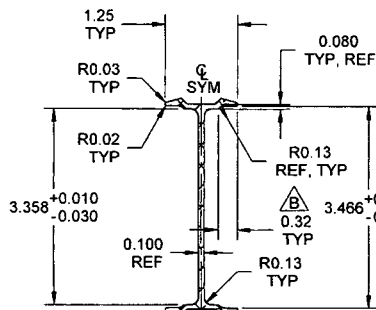
# **D3885-3 FLOAT WEB**

**RELEASED**  
09/15/15

- D3885-3 NOTES:**
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 10.14 lbs

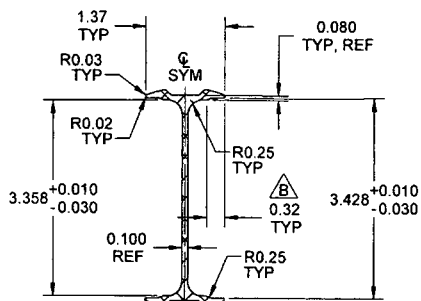
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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8 7 6 5 4 3 2 1

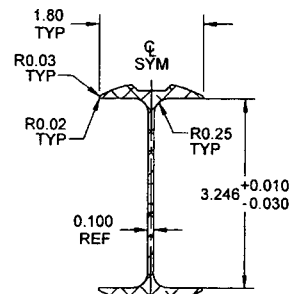


**SECTION K-K  
& SECTION T-T  
& SECTION U-U  
& SECTION X-X**  
SCALE 5X

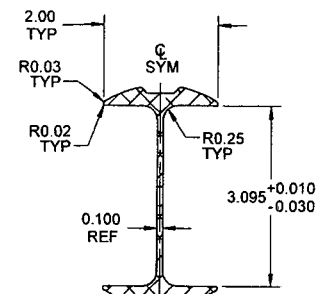
D7-4  
D4-4  
D3-4  
D1-4



**SECTION L-L** D6-4  
SCALE 5X

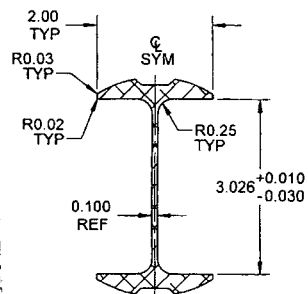


**SECTION M-M** D6-4  
SCALE 5X

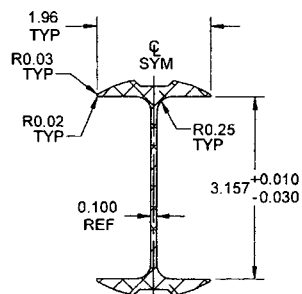


**SECTION N-N** D5-4  
SCALE 5X

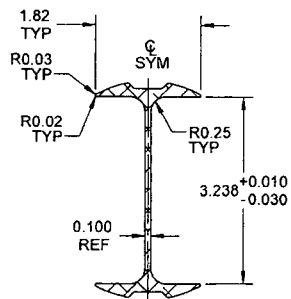
RELEASED  
9/27/15



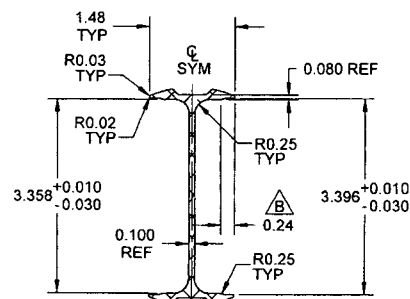
**SECTION O-O  
& SECTION P-P** D5-4  
SCALE 5X



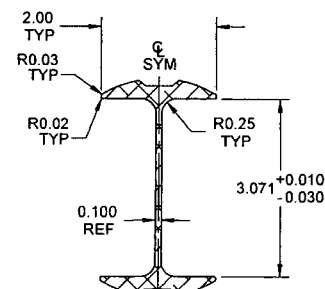
**SECTION Q-Q** D4-4  
SCALE 5X



**SECTION R-R** D4-4  
SCALE 5X




**SECTION S-S** D4-4  
SCALE 5X



**SECTION V-V  
& SECTION W-W** D3-4  
D2-4  
SCALE 5X

**D3885-3 FLOAT WEB SECTION VIEWS**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO24244**

Purchase Order Date 5/16/2014

PO Print Date 5/16/2014

Page Number 1 of 2

Order From : VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD  
600 O'CONNOR DRIVE  
KINGSTON, ONTARIO K7P 1N3  
CANADA

Ship To : DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms COD

Currency CAD

FOB Destination-Collect

Chantal Lavoie

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
1	D3885-1P	Standard Web	6/6/2014 Yes 6/6/2014		21.00 Each	\$510.00	\$10,710.00

MACHINE AS PER DWG D3585-1 REV. B  
B119039

Line Total: \$10,710.00

2	71401-45	PROCUREMENT QUALITY CLAUSES	6/6/2014		1.00	\$0.00	\$0.00
---	----------	-----------------------------	----------	--	------	--------	--------

No

6/6/2014

Procurement Quality Clauses  
A005 RIGHT OF ENTRY  
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER,  
(DOCUMENTATION SENT TO DART AEROSPACE)  
A016 PERSONNEL QUALIFICATION  
A017 RAW MATERIAL IDENTIFICATION (AS  
APPLICABLE)  
A024 PROCESS CERTIFICATIONS  
A025 CERTIFICATE OF CONFORMANCE  
A040 NOTIFICATION OF QUALITY ESCAPE  
A042 DART NOTIFICATION BY SUPPLIER  
A043 RETENTION OF QUALITY DOCUMENTS

Note:

5/16/2014



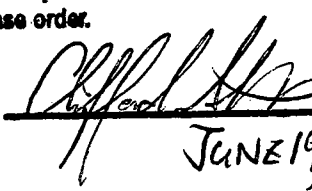
Packing Slip 36854

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

TEL: 613-384-1662 FAX: 613-384-2997

www.wejay.com

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Dart Aerospace  
1270 Aberdeen Street  
Hawkesbury ON K6A 1K7S  
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Dart Aerospace  
1270 Aberdeen Street  
Hawkesbury ON K6A 1K7

INVOICE DATE		YOUR ORDER NO. PO24244		DATE ORDERED 05/20/14		SHIPPED VIA Best way	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra <input type="checkbox"/> Exempt <input type="checkbox"/>		TERMS	
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
21	-	21	Machine standard web as per drawing D3885-1, Rev. B Part number: D3885-1F				
			B119039 DAS 27 9/89 M/6/24 Required by: <del>June 6, 2014</del> JUNE 20				
			<b>RELEASE NOTE</b> I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor  JUNE 19/14				
			WMP 03			G.S.T.	
						P.S.T.	

ORDER: COMPLETE ☐  
PARTIAL ☐**TOTAL**

RECEIVED BY \_\_\_\_\_

1.5% PER MONTH (18% PER ANNUM)  
CHARGED ON OVERDUE ACCOUNTSNO GOODS RETURNED WITHOUT  
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

## CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: June 19, 2014		
	P.O.# PO24244		
	WEJAY JOB# 36854		
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
B-3885-1P 'Standard Web'	21	Machined complete per drawing req'ts.	B-3885 / rev. B
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

A handwritten signature in black ink, appearing to read 'Clifford Smith', is written over a circular stamp. The stamp contains the text 'WMP' at the top and '03' at the bottom.

**Clifford Smith**  
Authorized Q.A. Signatory





600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No. **36854**

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# **24244**

PART No. D3885-1P

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

**E. JANSEN**

QUANTITY  
REC'D: **1**

ACCEPT:  
**✓**

REJECT:

N.C.R.#

DATE:

**JUNE 19/2014**

INSTRUCTIONS, COMMENTS:

**FIRST ARTICLE INSPECTION**

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

1	Hole, Diameter .63"	18 places	+ .008/- .001		<b>.630 - .632 ✓</b>		
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		<b>1.001 - 1.002 ✓</b>		
3	5.51"		+/- .03		<b>✓</b>		
4	11.86"		+/- .03		<b>✓</b>		
5	13.11"		+/- .03		<b>✓</b>		
6	15.61"		+/- .03		<b>✓</b>		
7	16.86"		+/- .03		<b>✓</b>		
8	22.29"		+/- .03		<b>✓</b>		
9	24.04"		+/- .03		<b>✓</b>		
10	25.79"		+/- .03		<b>✓</b>		
11	30.14"		+/- .03		<b>✓</b>		
12	34.14"		+/- .03		<b>✓</b>		
13	38.67"		+/- .03		<b>✓</b>		
14	40.42"		+/- .03		<b>✓</b>		
15	43.71"		+/- .03		<b>✓</b>		
16	46.91"		+/- .03		<b>✓</b>		
17	50.91"		+/- .03		<b>✓</b>		
18	54.91"		+/- .03		<b>✓</b>		
19	58.91"		+/- .03		<b>✓</b>		
20	62.43"		+/- .03		<b>✓</b>		
21	67.43"		+/- .03		<b>✓</b>		
22	70.10"		+/- .03		<b>✓</b>		
23	74.10"		+/- .03		<b>✓</b>		
24	78.10"		+/- .03		<b>✓</b>		
25	82.10"		+/- .03		<b>✓</b>		
26	85.43"		+/- .03		<b>✓</b>		
27	88.01"		+/- .03		<b>✓</b>		
28	92.01"		+/- .03		<b>✓</b>		
29	96.01"		+/- .03		<b>✓</b>		
30	100.01"		+/- .03		<b>✓</b>		
31	103.43"		+/- .03		<b>✓</b>		
32	108.42"		+/- .03		<b>✓</b>		
33	109.67"		+/- .03		<b>✓</b>		
34	112.17"		+/- .03		<b>✓</b>		
35	113.42"		+/- .03		<b>✓</b>		
36	113.92" REF				<b>✓</b>		



600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No. **36854**

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# **24244**

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

**E. JANSEN**

QUANTITY

REC'D: **1**

ACCEPT:

**✓**

REJECT:

N.C.R.#

DATE:

**JUNE 9/2014**

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
37	1.25" TYP	Section A-A,J-J@93.63",40.63"			✓		
38	R.03" TYP				✓		
39	R.02" TYP				✓		
40	3.358"		+0.010/-.030		✓		
41	R.13" TYP				✓		
42	.32" TYP				✓		
43	3.466"		+0.010/-.030		✓		
44	R.13" TYP				✓		
45	.080 TYP,REF				✓		
46	1.37" TYP	Section B-B@90.63"			✓		
47	R.03" TYP				✓		
48	R.02" TYP				✓		
49	3.428"	2 places	+0.010/-.030		✓		
50	R.25" TYP				✓		
51	.32" TYP				✓		
52	R.25" TYP				✓		
53	.080" TYP,REF				✓		
54	1.80" TYP	Section C-C@81.63"			✓		
55	R.03" TYP				✓		
56	R.02" TYP				✓		
57	3.246"		+0.010/-.030		✓		
58	R.25" TYP				✓		
59	2.00" TYP	Section D-D@69.63"			✓		
60	R.03" TYP				✓		
61	R.02" TYP				✓		
62	3.095"		+0.010/-.030		✓		
63	R.25" TYP				✓		
64	2.00" TYP	Section E-E,F-F@64.63",60.63"			✓		
65	R.03" TYP				✓		
66	R.02" TYP				✓		
67	3.026"		+0.010/-.030		✓		
68	R.25" TYP				✓		
69	1.96"	Section G-G@53.63"			✓		
70	R.03" TYP				✓		
71	R.02" TYP				✓		
72	3.157		+0.010/-.030		✓		



600 O'CONNOR DRIVE  
KINGSTON, ONTARIO  
K7P 1N3

# INSPECTION / TEST REPORT

JOB No. **36854**

PAGE: 3 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# **24244**

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885

REV. B

E.C.O.

MATERIAL:

Extrusions supplied by DAS

INSPECTOR:

**E. JANSEN**

QUANTITY  
REC'D: 1

ACCEPT: ☒

REJECT:

N.C.R.#

DATE:

**JUNE 9 / 2014**

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
---------------------	----------------	---------	-----------	-----------------	--------	---------------	---------------------------------------

73	R.25" TYP	Section G-G Cont'd			✓		
74	1.82"	Section H-H@47.63"			✓		
75	R.03" TYP				✓		
76	R.02" TYP				✓		
77	3.238"		+0.010/-0.030		✓		
78	R.25" TYP				✓		
79	1.48"	Section I-I@43.63"			✓		
80	R.03" TYP				✓		
81	R.02" TYP				✓		
82	3.358		+0.010/-0.030		✓		
83	R.25" TYP				✓		
84	3.396"		+0.010/-0.030		✓		
85	R.25" TYP				✓		
86							
87							
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